

Work Order ID 52071

September 16, 2009 8:30:05 AM

Page 1

Item ID: D3578-041

Accept

Revision ID: A

Item Name: Doubler

Setup Start

Stop

Start Date: 09/16/2009 Start Qty: 60.00

Required Date: 09/22/2009 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-9-16

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3578

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3578 (Run prog. D3578-1) ☒ Dwg Rev: A ☐ Prog
Rev: A ☐ 2-Deburr if necessary

80 09/09/17

108

AB 9-9-16

108

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

AB 9-9-16

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

2) 09/09/17

counted
108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52071

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Item ID: D3578-041

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Setup Start



Revision ID: A

Item Name: Doubler

Stop



Start Date: 09/16/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 09/22/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

09/09/18 (108)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2> Scoring

counted
(X/108) /

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

mp 09/09/21

(X/108)

190 / Packing

247A

9/9/24 (108X) SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52071

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Item ID: D3578-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 09/16/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 09/22/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
			m. h 09/09/21			(108X)			
170 Small Fab Small Fab	Small Fab Memo 1-Assemble as per dwg D3578	0.00 0.00							
			509/09/23			(108)			
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			2) 807/09/23			(count 408)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52071

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Item ID: D3578-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 09/16/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 09/22/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: ST 244A 0.00

Packaging

Memo

0.00

Packaging

MF 09-09-25

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/25

MF 09-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 16, 2009 8:30:05 AM

Page 1
Z

Work Order ID: 52071



Parent Item: D3578-041RevA



Parent Item Name: Doubler

Start Date: 09/16/2009

Required Date: 09/22/2009

Comments:

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3569-1RevA Decal		Manufactured	No			110	Each	22.0000	60.0000			
<div style="position: relative; height: 100px;"> <div style="position: absolute; top: 0; left: 0; width: 100%; height: 100%; border: 1px solid black; transform: rotate(-15deg);"></div> <div style="position: absolute; top: 10%; left: 30%; font-size: 2em;">N</div> <div style="position: absolute; top: 10%; left: 45%; font-size: 2em;">A</div> <div style="position: absolute; top: 10%; left: 50%; transform: rotate(-15deg); font-size: 1.5em;">WF 09-04-25</div> </div>												
			<u>Warehouse</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
			<u>Location</u>									
			Main Warehouse									
			ST				22					
			32084				22					
MS20426AD3-3 Rivet		Purchased	No			110	Each	7,385.000	120.0000			
			<u>Warehouse</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
			<u>Location</u>									
			Main Warehouse									
			ST				7385					
			1563				0					
			19099				4776					
			7681				2609					

09/09/23
218

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 52071



Parent Item: D3578-041RevA



Parent Item Name: Doubler

Start Date: 09/16/2009

Required Date: 09/22/2009

Comments:

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			170	sf	262.7381	0.4421			
6061-T6 .080 Sheet											18 9-9-16	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	262.7381	
107904	0.02	
110254	2.5	
110630	41.5244	110630
112040	0.0437	
112141	33	
112512	185.65	

MS21075L3		Purchased	No			170	Each	193.0000	60.0000			
Nutplate											Ep 09/09/23	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	193	
109068	12	
109371	39	
110704	37	
111477	2	
112314	13	
112640	90	

M 112690

108

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

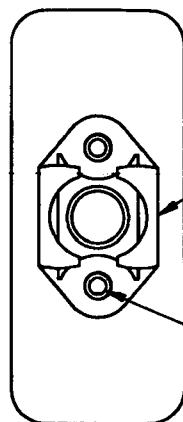
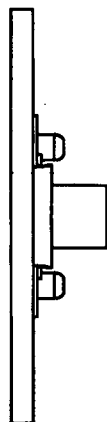
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LET</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12	TITLE DOUBLER		SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



D3578-1 PLATE

MS21075L3 NUT PLATE

MS20426AD3-3 RIVET
(2 PLACES)

RELEASED
07-04-02

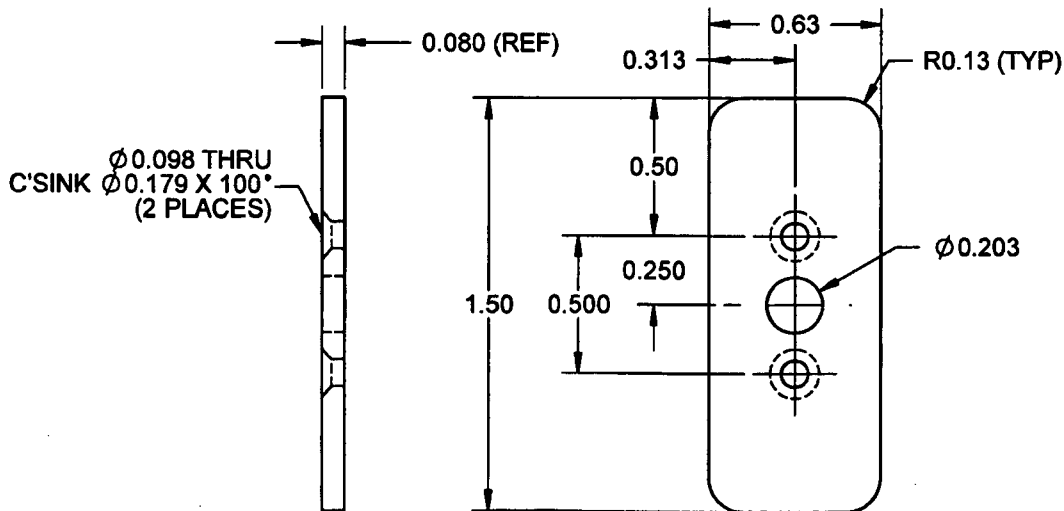
D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER

D3578-041 NOTES:

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



D3578-1 PLATE

D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WORK ORDER
NO. *52071*

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